

Jan

Work Order ID 64508

Tuesday, December 07, 2010 9:07:35 AM



Page 1

Item ID: D2281

Accept



Setup Start



Revision ID:

Stop



Item Name: Jack Saddle

Start Date: 12/7/2010 Start Qty: 150.00



Cust Item ID:

Required Date: 1/21/2011 Req'd Qty: 150.00



Customer:

Reference:

Approvals:

Process Plan:

M

Date:

10-07

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2281

Rev G

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2281

☐ Dwg Rev:

G

☐ Prog Rev:

G

☐ 2-

Deburr if necessary

B10-12-8

(FO)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B10-12-8

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

10 12 08

*150
count*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00



Small Fab

0.00

Small Fab

Memo

N/A

Small Fab

Debur

140

0.00



NC BRAKE

0.00

Brake NC

Memo

SP 10/12/13

Brake NC

Form as per D2281 using D2281-T2

150

150

0.00



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

8 10/12/14

count
x150

Quality Control

W/O:		WORK ORDER CHANGES					
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Work Order ID 64508

Page 3

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Accept



Setup Start



Revision ID:

Stop



Item Name: Jack Saddle

Start Date: 12/7/2010 Start Qty: 150.00



Cust Item ID:

Required Date: 1/21/2011 Req'd Qty: 150.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location <u>263</u>	0.00							
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

10/12/15 (100)

10/12/15 MK
10-12-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, December 07, 2010 9:07:40 AM

Page 1

Work Order ID: 64508

Parent Item: D2281

Parent Item Name: Jack Saddle



Start Date: 12/7/2010

Required Date: 1/21/2011

Start Qty: 150.00

Required Qty: 150.00

Comments: IPP Rev:A Removed from 9 Digit 05-12-02 JLM
IPP: rev B ☐ 06.07.17 ☐ waterjet ☐ EC ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S14GA		Purchased	No			100	sf	99.1108	0.125	19.73684			



304SS sheet .080



12-12-8

Location

Loc Qty

Loc Code

MAT20

99.1108

113295

99.1108

113295

150

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	14808
Description: Jack Saddle		Part Number:	D2281
Inspection Dwg: D2281 Rev: G		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.468	+/-0.010	4.472	X		V B02	
4.114	+/-0.010	4.113	X		V	
2.933	+/-0.010	2.934	X		V	
1.535	+/-0.010	1.536	X		V	
0.354	+/-0.010	0.352	X		V	
0.354	+/-0.010	0.354	X		V	
0.604	+/-0.010	0.604	X		V	
2.000	+/-0.010	2.002	X		V	
3.396	+/-0.010	3.396	X		V	
3.646	+/-0.010	3.646	X		V	
4.000	+/-0.010	4.010	X		V	
1.525	+/-0.010	1.524	X		V	
2.475	+/-0.010	2.477	X		V	
Ø0.323	+0.006/-0.001	0.324	X		V	
0.080	+/-0.010	0.084	X		V	

Measured by: B	Audited by: M.L.M.	Prototype Approval:	N/A
Date: 10-12-8	Date: 10/12/09	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.09.08	New Issue	KJ/JLM	

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

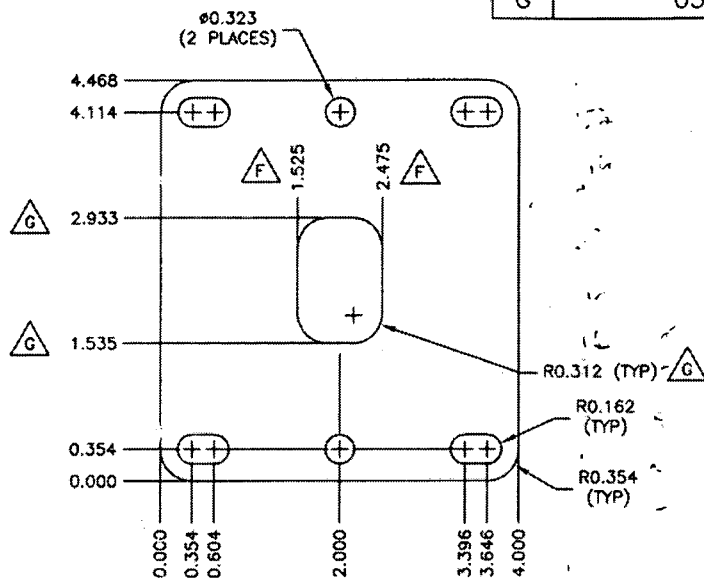
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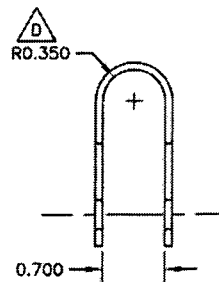
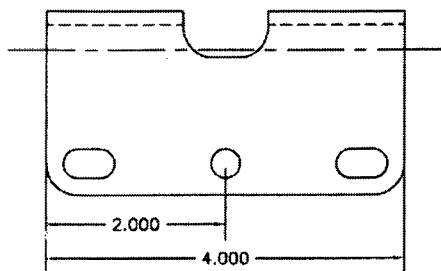


DESIGN BW	DRAWN BY <i>FE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>UP</i>	APPROVED <i>MS</i>	DRAWING NO. D2281	REV. G SHEET 1 OF 1
DATE 05.06.07	TITLE JACK SADDLE		SCALE 1:2
A	94.10.14	NEW ISSUE	
B	94.10.18	DIMENSION WAS 2.878	
C	94.11.04	ADD TOOLING NOTCH	
D	98.03.27	R0.350 WAS R0.280	
E	04.11.18	REMOVE TOOLING NOTCHES	
F	05.03.16	REDESIGN FLAT PATTERN	
G	05.06.07	REDESIGN FLAT PATTERN	

RELEASED
MS
05/08/11



FLAT LAYOUT



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *44508*
01/10-127

D2281 JACK SADDLE

- 1) MATERIAL: 304/316 SS, 0.080 THICK (REF DART SPEC. M304S14GA)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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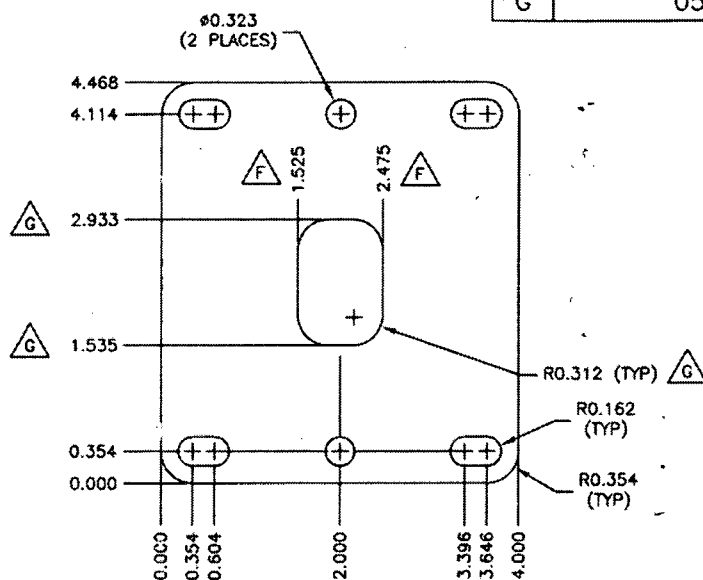
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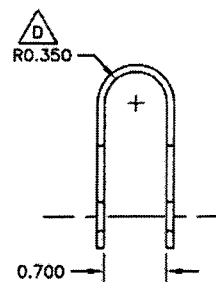
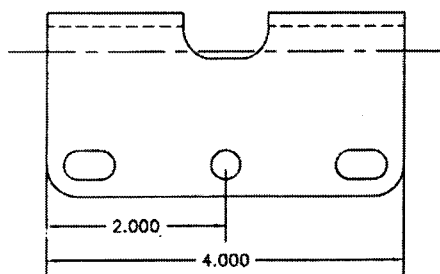


DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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[Signature]
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